



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1703
Job Sheet 212914



Part No: 647.1703

Job Qty: 4 ea

Part Name: Skid Deflector Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/9/20

Job Tracking No:

Due Date: 9/15/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: 647.1700 REV.F IPP REV:A NEW ISSUE 15-06-09 JLM VERIFIED BY:DD IPP REV:B 20.07.07 AS PER DWG
REV.F DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Small Fab - 1	4 pcs	9/15/20		0.00	6.00	Small Fab - 1		DAS 58 9-89 SEP 15 2020
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
							Small Fab - Various 1		
130	QC 5	4 pcs	9/15/20		0.00	0.00	QC 5 - 10		DAS 82 9-89 SEP 16 2020
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		

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210 Packaging 3-1 - Stock - B4B 4 pcs	9/15/20	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	DAS
			Packaging 3 - 7 - B4B	28
			Packaging 3 - 8 - B4B	9-89
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	SEP 17 2020
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	DAS
220 QC21-SA 4 Ea	9/15/20	0.00 0.00	QC 21 - SA - 21	21 SEP 17 2020

Part Op 120 - 1- Assemble item 4,6,7 and 8 as per dwg. 2- Clamp item 1 and 2 to item 3. Transfer drill holes as per dwg see note
 Descriptions: 6. Use clecos. 3- Disassemble parts 4- Deburr 5- Touch up expose aluminum with alodine *** **TOUCH UP RIVET WITH
 PRIMER *** PRIMER BATCH: _____ *** 6- Re-assemble as per dwg
 130 - QC5- Inspect part completeness to step on W/O
 210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 220 - QC21- Final Inspection - Work Order Release

CITB83

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.1713 CCK107	Spacer	4 pcs (1 ea)	120-Small Fab - 1	5046687
647.1716 052	Plate	4 pcs (1 ea)	120-Small Fab - 1	5149976
647.1717 11	Plate	4 pcs (1 ea)	120-Small Fab - 1	5149977
647.1718 31	Gusset	4 pcs (1 ea)	120-Small Fab - 1	5149978
CR3213-4-4	Rivet, Cherry	88 Ea (22 ea)	120-Small Fab - 1	5087981
MS21042L3	Nut	4 Ea (1 ea)	120-Small Fab - 1	5295723
MS27039-1-14	Screw	4 Ea (1 ea)	120-Small Fab - 1	5295724
NAS1149F0332P	Washer (AN960-10L)	8 Ea (2 ea)	120-Small Fab - 1	5297090

V10
523124
523124

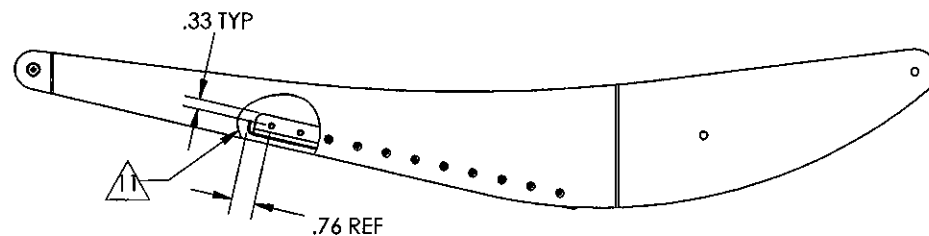
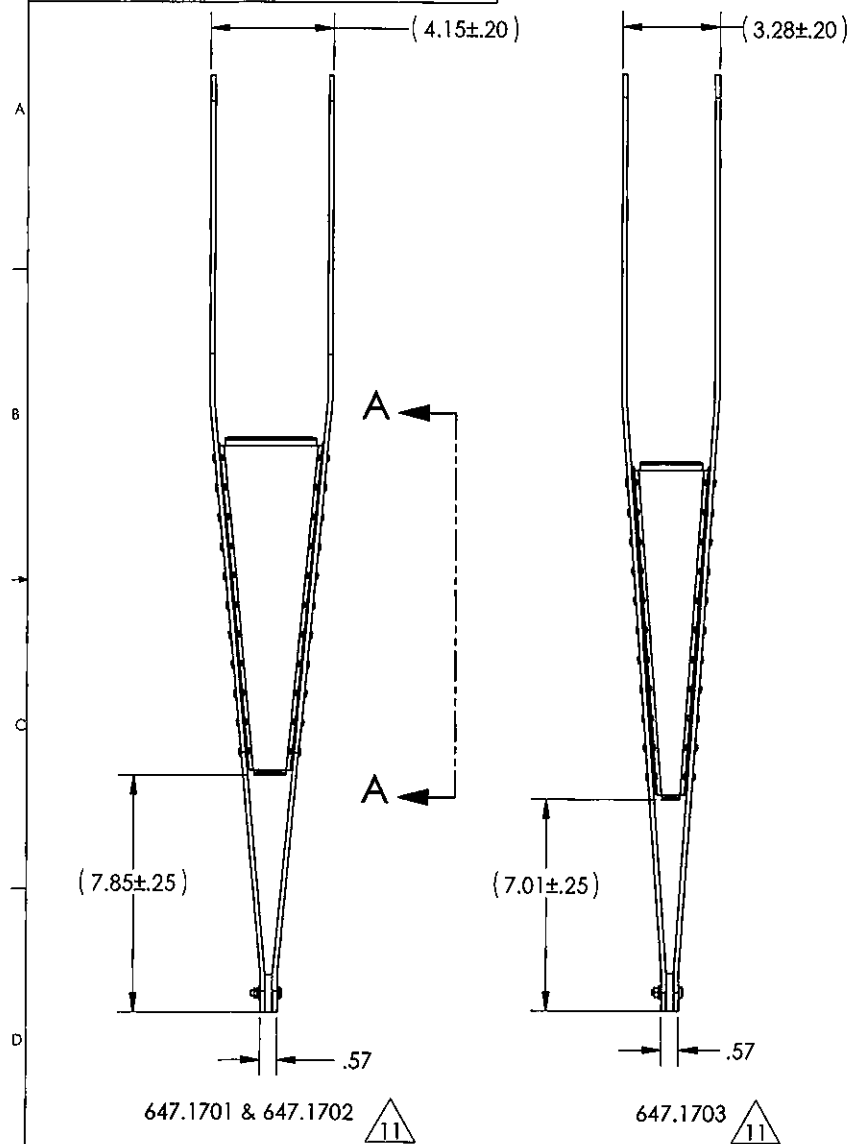
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	647.1713	4	34	0
	647.1716	4	6	0
	647.1717	4	12	0
	647.1718	4	14	0
	CR3213-4-4	88	199	0
	MS21042L3	4	817	0
	MS27039-1-14	4	374	0
	NAS1149F0332P	8	2,114	0
Part Specifications				
Specifications could not be found.				

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14 FOR P/N 647.1703 ASSEMBLY.

1			13	647.1718	GUSSET	△	△	
1			12	647.1717	PLATE	△	△	△
1			11	647.1716	PLATE	△	△	△
	1		10	647.1715	PLATE	△	△	△
	1		9	647.1714	PLATE	△	△	△
1	1	1	8	601.1622	SCREW	M22039-1-14		
1	1	1	7	601.2943	LOCKNUT	M21042-3		
2	2	2	6	601.1607	WASHER	NAS1149F0332P		
22	22	22	5	601.1915	RIVET	CR3213-4-4		
1	1	1	4	647.1713	SPACER	△	△	△
	1	1	3	647.1712	GUSSET	△	△	△
		1	2	647.1711	PLATE	△	△	△
		1	1	647.1710	PLATE	△	△	△
X				647.1703	SKID DEFLECTOR ASSY			
	X			647.1702	SKID DEFLECTOR ASSY			
		X		647.1701	SKID DEFLECTOR ASSY			
.1703	.1702	.1701	FIND #	PART #	DESCRIPTION	MAT'L	SPEC	
QTY				PARTS LIST				
NEXT ASSY (S)			ORIGINAL DATE 18/04/95		DRAWING 1 CHECKER 1 BY BRANK		3030 ENTERPRISE C SUITE A VISTA, CA. 92083 (760)724-5300	
647.1300			DRAWING APPROVAL BY BRANK 05/05/99 CONTRACT NO.		APICAL INDUSTRIES, INC. 3030 DART AEROSPACE			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ANGLES ± .5°		DART AEROSPACE			
					APICAL INDUSTRIES, INC. 3030 DART AEROSPACE			
					SKID DEFLECTOR ASSY			
SIZE B		CASE CODE 07A26		DWG. NO. 647.1700		REV. F		
SCALE NONE					SHEET 1		OF 7	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF DART AEROSPACE IS PROHIBITED.



SECTION A-A
DIMENSIONS TYP ALL CONFIGURATIONS 11

ORIGINAL DATE 06/04/00		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 724-5300	
DRAWN BY J. GARDNER		CHECKED BY P. BRAYO	
DRAWING APPROVAL P. BRAYO		APICAL INDUSTRIES, INC. DART AEROSPACE	
CONTRACT NO.		SKID DEFLECTOR ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET B	REV. F
SCALE NONE		SHEET 2 OF 7	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

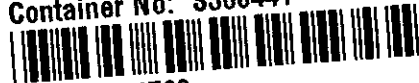
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S300441



Part: 647.1703

Job No: 212914

Serial No/Batch: S300441

Revision: REV.F

Inspector:

Exp Date:

Instructions:

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5280
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/15/20